

Work Order ID 81237

81237

Page 1

March-12-12 12:40:26 PM

Item ID: D206-642-312

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH

Stop *NS2*

Start Date: 12/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/03/12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-642

O

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

ML5 12-4-2

SP-12-04-02

12/04/13

B81245

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81237***81237***

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March-12-12 12:40:26 PM

Item ID: D206-642-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH

Stop ***NS2***

Start Date: 12/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-642-312

Location:

PPP Rev: 7

1x 80 D-04-03

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/4/4

MF
12-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81237

81237

Parent Item: D206-642-312

D206-642-312

Parent Item Name: Skidtube RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP
 Rev: M 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341		Manufactured	No			110	Each	3.0000	1	1			
D206-642-341									**			8/24/8	
Replacement Skidtube													

Location	Loc Qty	Loc Code
FG081	1	
57156	0	
57160	0	
57161	0	
69950	1	
FG082	2	
36550	1	
69952	1	

D206-648-013

CHG002

Manufactured No

110 Each

11.0000

D206-648-013

GHW Modification

**

8/12-04-02

Location	Loc Qty	Loc Code
FG	5	
78875	5	
FG125	6	
75825	2	
78874	4	

(x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81237

81237

Parent Item: D206-642-312

D206-642-312

Parent Item Name: Skidtube RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2932-2

Manufactured No

110

Each

13.0000

1

1

**

D2932-2

Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

6

79224

6

ST428

7

74602

3

75100

4

Manufactured No

110

Each

10.0000

1

**

D2933-2

D2933-2

Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

6

79227

6

ST428

4

75101

4

Manufactured No

110

Each

13.0000

**

D2938-2

D2938-2

Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

6

79229

6

ST428A

7

74606

1

75102

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 81237

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

81237

D206-642-312

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2939-2

Manufactured No

110

Each

9.0000

D2939-2

Saddle RH In, 206

****** (1) (1)

B74608

SP L

Location

Loc Qty

Loc Code

ST421

6

79231

6

ST428A

3

75103

3

Purchased

No

110

Each

475.0000

****** 8 8

SP

L

AN3-41A

AN3-41A

Bolt

Location

Loc Qty

Loc Code

ST335

275

120644

275

ST354

200

120498

200

Manufactured

No

110

Each

855.0000

****** 16 16

SP 12-01-02 L

D2652

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

811

73834

15

73836

36

76134

1

76135

19

76136

55

77134

400

77136

285

160x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 81237

81237

Parent Item: D206-642-312

D206-642-312

Parent Item Name: Skidtube RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

3,226.000

8 8

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

3226

117441

16

117885

32

118451

5

118927

3

119017

2990

119075

180

8x

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8 8

**

AN960JD10

Washer

AN5-10A

Purchased

No

110

Each

414.0000

4 4

**

AN5-10A

Bolt

Location

Loc Qty

Loc Code

ST337

414

118191

80

120630

50

120717

50

120770

234

4x

AN5-12A

Purchased

No

110

Each

46.0000

4 4

**

AN5-12A

Bolt

Location

Loc Qty

Loc Code

ST338

46

117313

46

4x

March-12-12 12:40:30 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 81237

81237

Parent Item: D206-642-312

D206-642-312

Parent Item Name: Skidtube RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-11A

Purchased

No

110

Each

753.0000

{ 8 }

8

**

AN5-11A

Bolt

Location

Loc Qty

Loc Code

ST337

753

118191

13

119512

740

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

{ 8 }

8

**

AN960JD516

Washer

AN4-6A

Purchased

No

110

Each

1,745.000

{ 12 }

12

**

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

1745

119017

1745

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

14.0000

{ 24 }

24

**

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81237

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

81237

D206-642-312

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

3,831.000

12

12

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

3831

117441

51

117601

157

118451

133

119017

200

119075

3290

Manufactured

No

110

Each

45.0000

1

**

D3407-043

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST420

16

79232

16

ST463

28

68339

2

74519

11

78841

15

ST464

1

68339

0

71040

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 7

Work Order ID: 81237

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

81237

D206-642-312

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

89.0000

1
**

1
S

D3456-1
Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

16

77486

16

ST044

66

66848

3

71165

2

73493

11

80252

50

D3457-1

Manufactured No

110

Each

63.0000

2
**

1x
2
S

D3457-1
Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

53

67779

1

76231

11

78801

41

MS21043-4

Purchased No

110

Each

1,213.000

1
**

2x
1
S

MS21043-4
Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1173

119546

415

120308

758

12-04-02.

1x

March-12-12 12:40:30 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 81237

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

81237

D206-642-312

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

AN4C5A

BOLT

Purchased No

110 Each 269.0000

**

Location

Loc Qty

Loc Code

ST355

269

112243

169

119017

100

110 Each

0.0000

**

AN960C416

NAS1149C0463

R

Purchased No

110 Each

0.0000

**

AN960C416

washer

D3413-1

Manufactured No

110 Each

79.0000

**

D3413-1

Ring

Location

Loc Qty

Loc Code

ST420

21

70773

1

79233

20

ST464

58

76754

34

77940

2

80224

22

110 Each

832.0000

**

D2712

D2712

Set Screw

Manufactured No

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

500

79585

500

ST021

282

76065

282

March-12-12 12:40:30 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-12-12 12:40:30 PM

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Work Order ID: 81237

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

81237

D206-642-312

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2934

Manufactured No

110

Each

92.0000

2

2

**

SP

✓

D2934

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

86

74501

1

74883

31

78802

54

2x

D2935

Manufactured No

110

Each

118.0000

2

2

**

SP 12-03-30

✓

D2935

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

112

74503

2

74882

26

78807

84

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-347	WEARSHOE KIT (REPLACES -343)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-11	WEARSHOE (REPLACES D2656-11)
22B					1	1				D3536-11	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-35	WEARSHOE (REPLACES D2656-35)
24B					1	1				D3536-35	GASKET
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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